

Work Order ID 126709

126709

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Monday, November 24, 2014 8:02:48 AM

Item ID: D3873-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 11/24/2014 Start Qty: 80.00

80

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11-11-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3873	C

100 0.00

100

Hardinge

Memo

0.00

82

86

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA806 & DWG D3873 ,
FOLIO REV: AA
DWG REV: C

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

82

86

Quality Control

11.12.07

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Monday, November 24, 2014 8:02:48 AM

Item ID: D3873-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 11/24/2014 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 11/24/2014 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 37 9-89 14-12-09
120						82	Ø		
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: <u>St063</u>	0.00							DAS 06 9-89
130						82			DEC 09 2014
Packaging	Memo	0.00							
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/12/109
 MF
 14-129

Picklist Print

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Work Order ID: 126709

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Parent Item: D3873-1

D3873-1

Parent Item Name: Bushing

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 80.00

Required Qty: 80.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No			100	f	75.6015	0.06	6			

M303R0 625

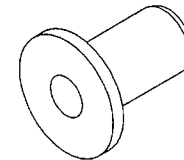
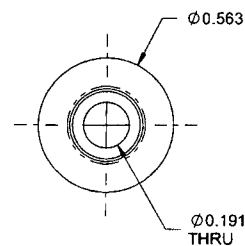
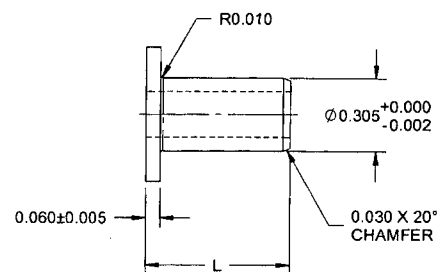
303 Round Bar 0.625"

**

Location	Loc Qty	Loc Code
MAT028	75.6015	
119009	43.5385	
124081 -	32.063	

6

BG 11.12.08



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126709 MLS

14-11-24

D3873-X BUSHING

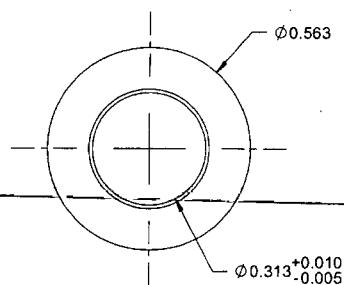
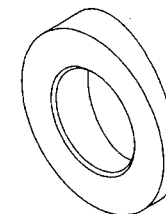
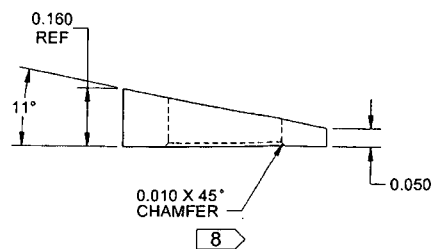


DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007

RELEASED
2011-09-12

- NOTES:
- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: PER TABLE

REV.	DESCRIPTION	BY	DATE
C	ADD D3873-3/-5/-7 (ZN B6-1 & B5-2)	RF	11.06.14
B	Ø0.563 WAS Ø0.63 (C3-1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
DESIGN	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3873	SHEET 1 OF 2
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	BUSHING	NTS
DATE	11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



C **D3873-7 SPACER**

RELEASED
2011-09-12
AV

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3873	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BUSHING	NTS
DATE	11.06.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

